



Work Order ID 62432

September 30, 2010 8:00:11 AM




Page 1


Item ID: D4172-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Pod Mounting Frame Assembly
Start Date: 9/30/10 Start Qty: 1.00  Cust Item ID:
Required Date: 10/15/10 Req'd Qty: 1.00  Customer:
Reference:


Approvals: Process Plan: C2 Date: 10/9/30 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4172	A								

100  0.00
Small Fab **Memo** 0.00
Small Fab 1- Transfer drill holes, deburr and assemble as per dwg

ET 10-10-14

110  0.00
QC **Memo** 0.00
Quality Control

1  10/10/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4172-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Pod Mounting Frame Assembly

Start Date: 9/30/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/21 *dg*
MF
10-10-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 30, 2010 8:00:11 AM

Page 1

Work Order ID: 62432

Parent Item: D4172-041

Parent Item Name: Pod Mounting Frame Assembly

















Start Date: 9/30/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4172-043 		Manufactured	No			100	Each	0.0000	1	1			
Z-Shape Section Assembly, LH						B62430				RT 10-10-13			
D4172-044 		Manufactured	No			100	Each	0.0000	1	1			
Z-Shape Section Assembly, RH						B62431				RT 10-10-13			
D4172-047 		Manufactured	No			100	Each	0.0000	5	5			
Crossbar Assembly						B62433				RT 10-10-13			
D4180-1 		Manufactured	No			100	Each	0.0000	1	1			
Gusset						B61924				RT 10-10-13			
D4180-2 		Manufactured	No			100	Each	0.0000	1	1			
Gusset						B61927				RT 10-10-13			
D4180-3 		Manufactured	No			100	Each	0.0000	1	1			
Gusset						B61925				RT 10-10-13			
D4180-4 		Manufactured	No			100	Each	0.0000	1	1			
Gusset						B61928				RT 10-10-13			
D4180-5 		Manufactured	No			100	Each	0.0000	1	1			
Gusset						B61926				RT 10-10-13			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

September 30, 2010 8:00:11 AM

Work Order ID: 62432

Parent Item: D4172-041

Parent Item Name: Pod Mounting Frame Assembly

Start Date: 9/30/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

D4180-6 Manufactured No

100 Each 0.0000

1 1



B61929



10-10-13

Gusset

D4181-1 Manufactured No

100 Each 0.0000

1 1



B61885



10-10-13

Pod Frame Platform

CR3213-4-04 Purchased No

100 Each 200.0000

38 38



104291

438



10-10-13

Rivet

Location

Loc Qty

Loc Code

ST312

200

115742

200

CR3213-4-06 Purchased No

100 Each 99.0000

24 24



115698



10-10-13

cherry rivet

Location

Loc Qty

Loc Code

ST312

99

115698

99

MS24694-500 Purchased No

100 Each 50.0000

4 4



M115531



10-10-13

Screw, Flat Head

Location

Loc Qty

Loc Code

ST303

50

115708

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

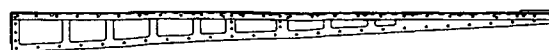
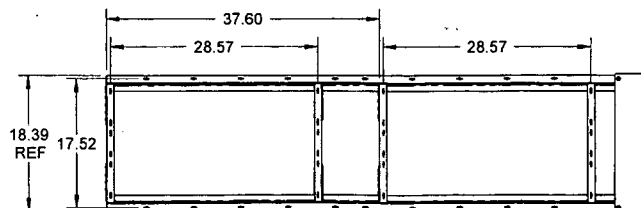
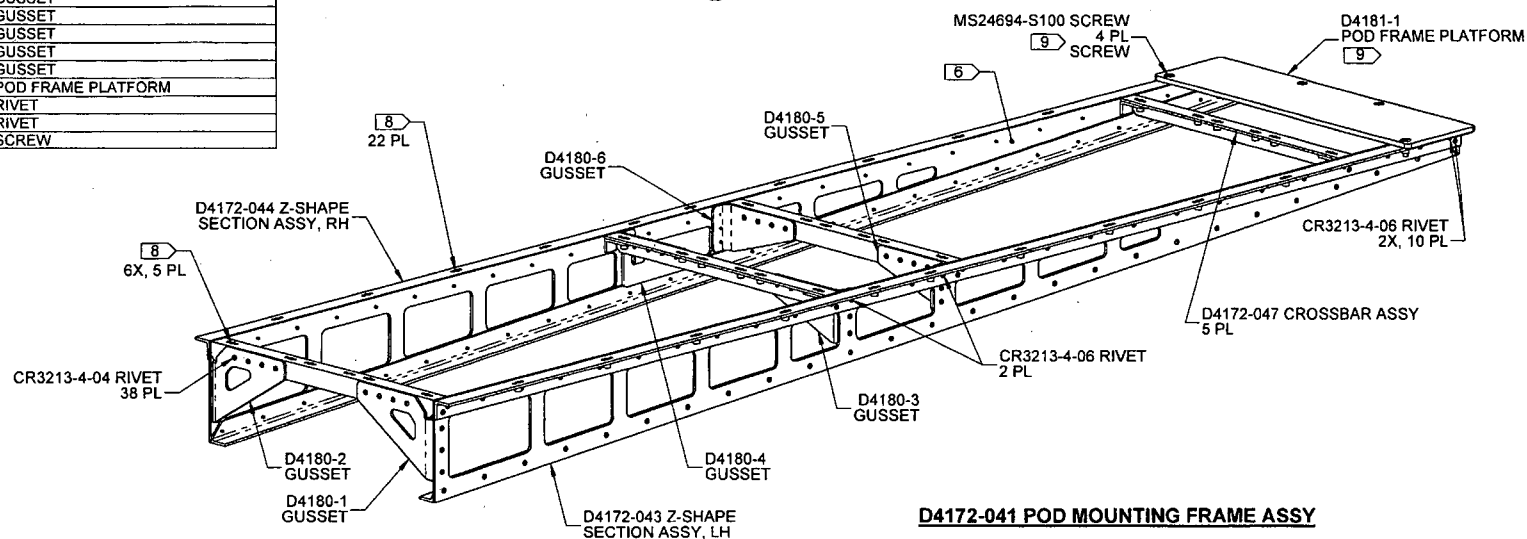
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY .041	P/N	DESCRIPTION
	X	D4172-041	POD MOUNTING FRAME
1	1	D4172-043	Z-SHAPE SECTION ASSY, LH
2	1	D4172-044	Z-SHAPE SECTION ASSY, RH
3	5	D4172-047	CROSSBAR ASSY
4	1	D4180-1	GUSSET
5	1	D4180-2	GUSSET
6	1	D4180-3	GUSSET
7	1	D4180-4	GUSSET
8	1	D4180-5	GUSSET
9	1	D4180-6	GUSSET
10	1	D4181-1	POD FRAME PLATFORM
11	38	CR3213-4-04	RIVET
12	24	CR3213-4-06	RIVET
13	4	MS24694-S100	SCREW

C210/9130

W10:62432



SUPPLEMENTAL VIEWS

D4172-041 POD MOUNTING FRAME ASSY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 7) WEIGHT: 15.0 lbs
- 8) MASK PRIOR TO POWDER COATING
- 9) INSTALL AFTER POWDER COATING

RELEASED
2010-09-29

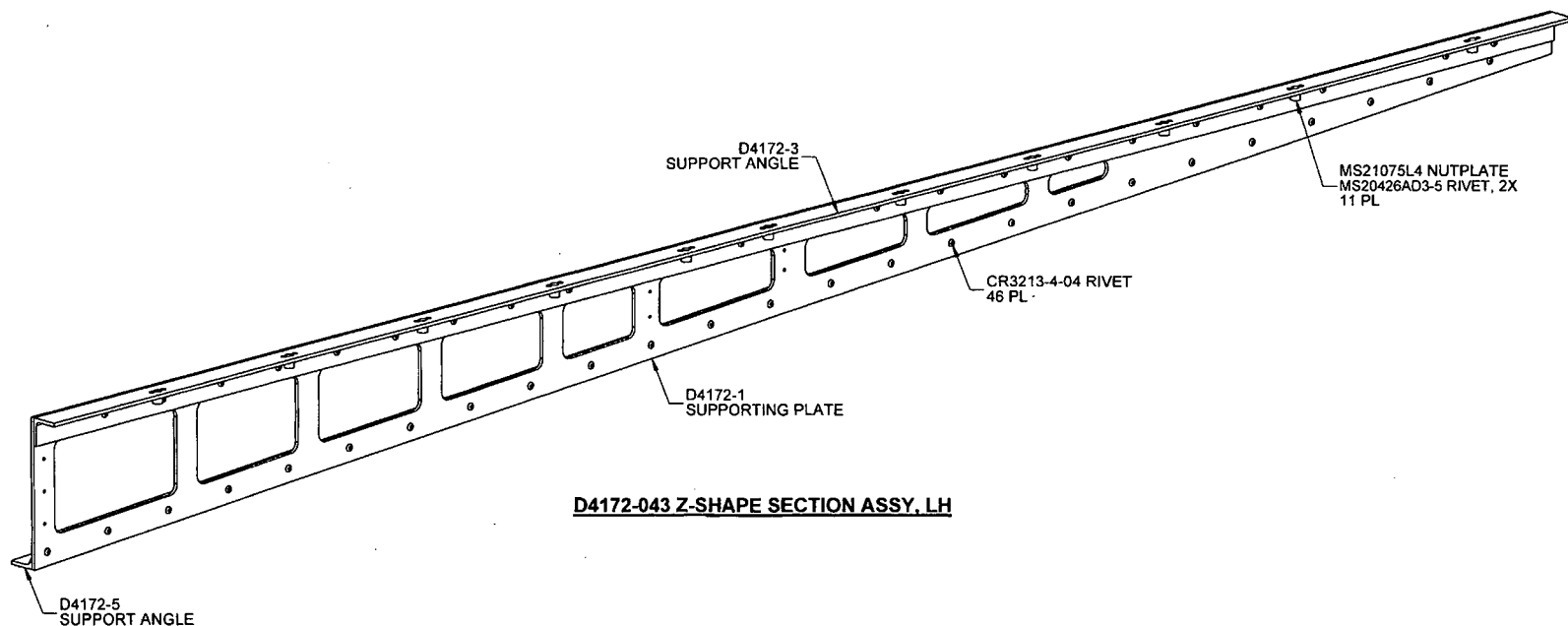
REV.	NEW ISSUE	DESCRIPTION	MB	10.09.15
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.09.15			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA







DRAWING NO. D4172
REV. A
SHEET 1 OF 7
TITLE: POD MOUNTING FRAME ASSY
SCALE: NTS

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ITEM	QTY -043	P/N	DESCRIPTION
	X	D4172-043	Z-SHAPE SECTION ASSY, LH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-3	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-5	RIVET
6	11	MS21075L4	NUT PLATE

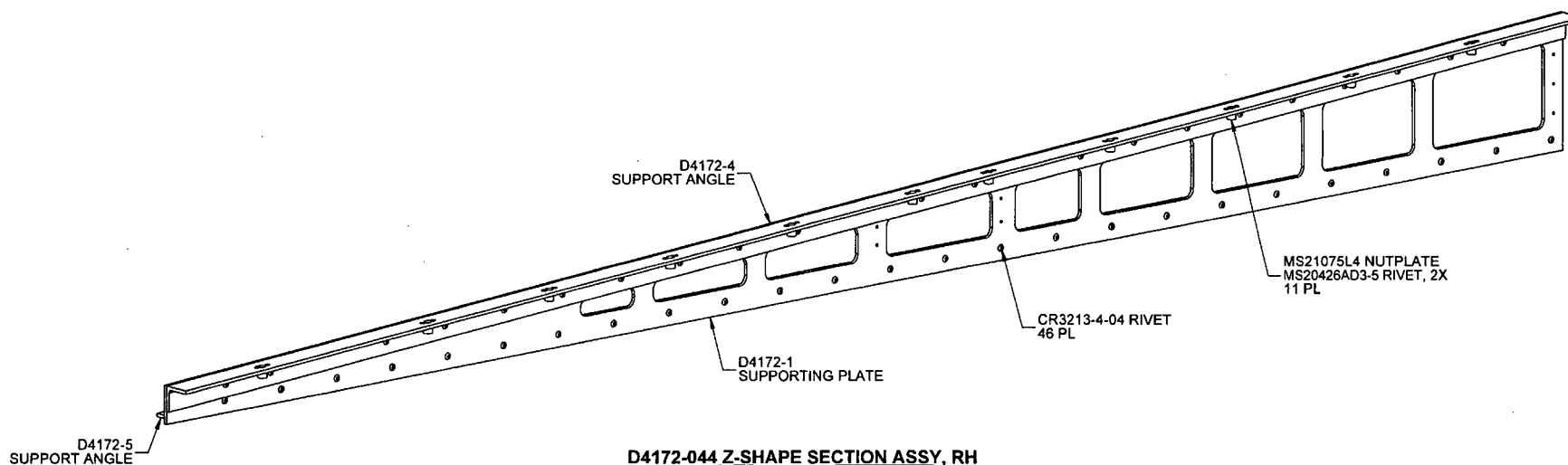


NOTES:
 1) MATERIAL: NONE
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 2.13 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4172	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		POD MOUNTING FRAME ASSY	NTS
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ITEM	QTY -044	P/N	DESCRIPTION
	X	D4172-044	Z-SHAPE SECTION ASSY, RH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-4	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-5	RIVET
6	11	MS21075L4	NUT PLATE



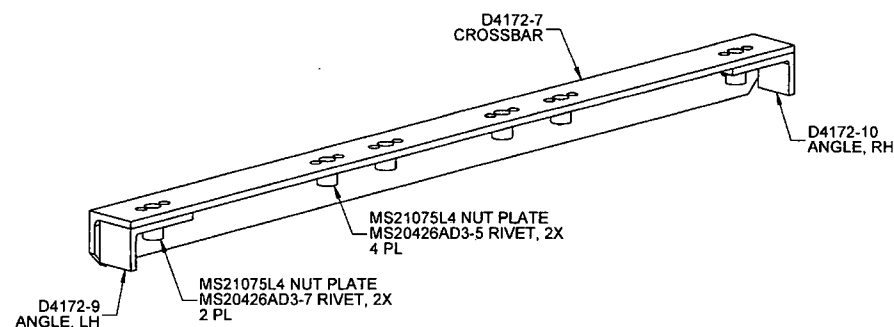
D4172-044 Z-SHAPE SECTION ASSY, RH

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NOTES:
 1) MATERIAL: NONE
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 2.14 lbs

DESIGN	J	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	R	DRAWING NO. D4172	REV. A
MFG. APPR.	R		SHEET 3 OF 7
APPROVED	10	TITLE	SCALE
DE APPR.	11	POD MOUNTING FRAME ASSY	NTS
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ITEM	QTY -047	P/N	DESCRIPTION
	X	D4172-047	CROSSBAR ASSY
1	1	D4172-7	CROSSBAR
2	1	D4172-9	ANGLE
3	1	D4172-10	ANGLE
4	6	MS21075L4	NUT PLATE
5	8	MS20426AD3-5	RIVET
6	4	MS20426AD3-7	RIVET



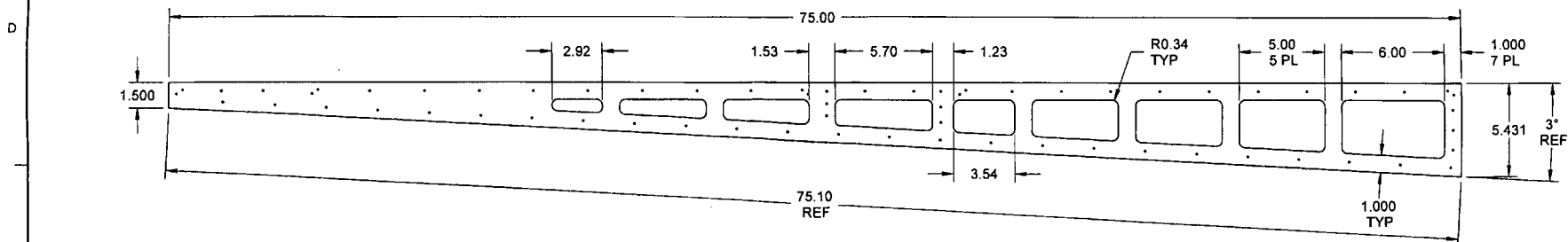
D4172-047 CROSSBAR ASSY

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2010-09-29
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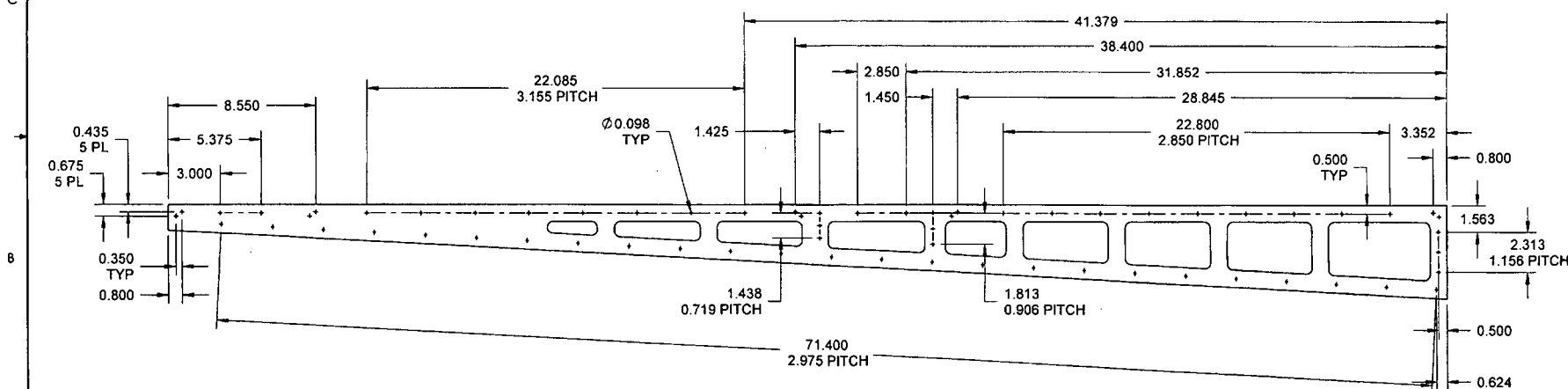
- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.18 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4172	SHEET 4 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	POD MOUNTING FRAME ASSY	NTS
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8 7 6 5 4 3 2 1



D4172-1 SUPPORTING PLATE



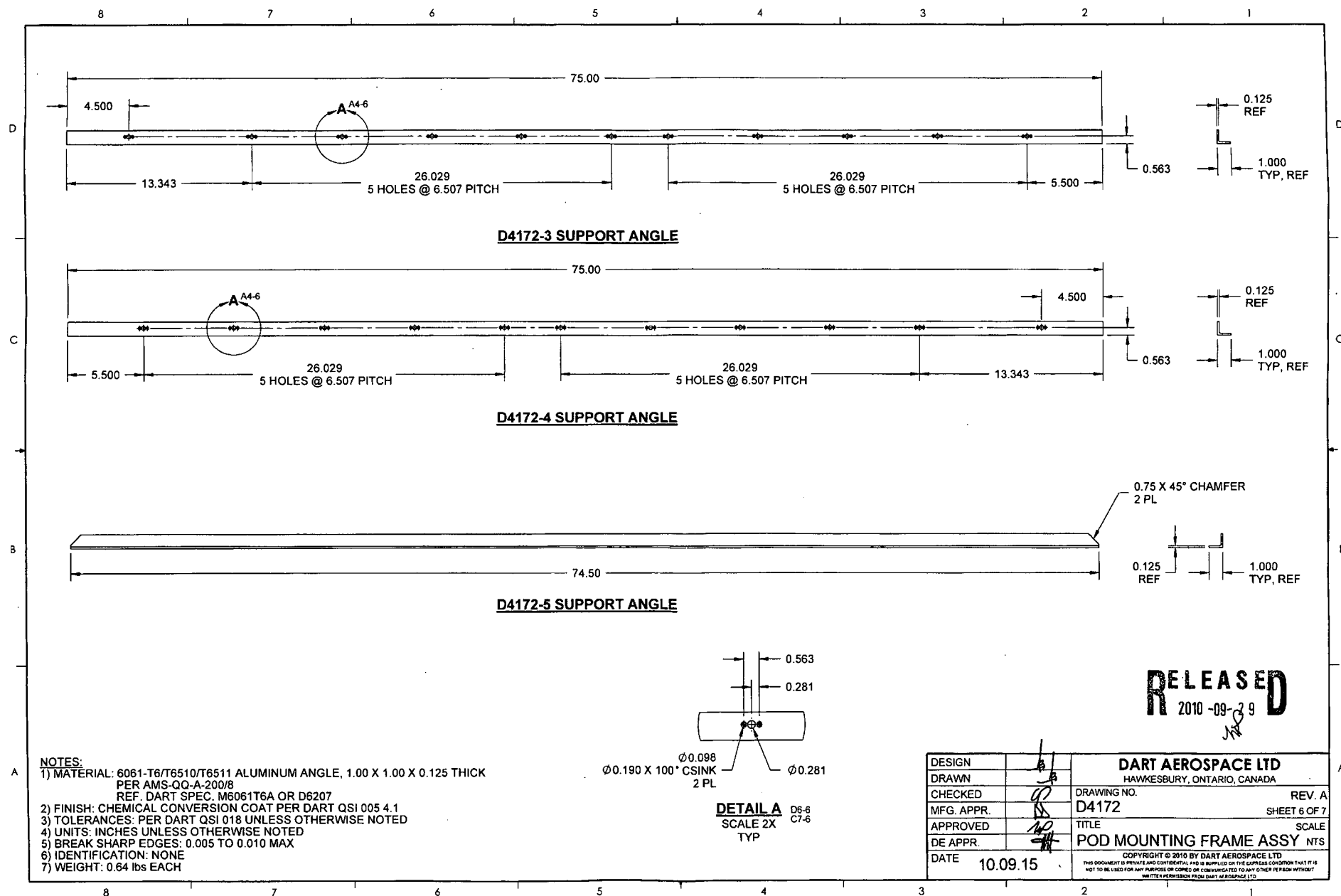
SUPPLEMENTAL VIEW

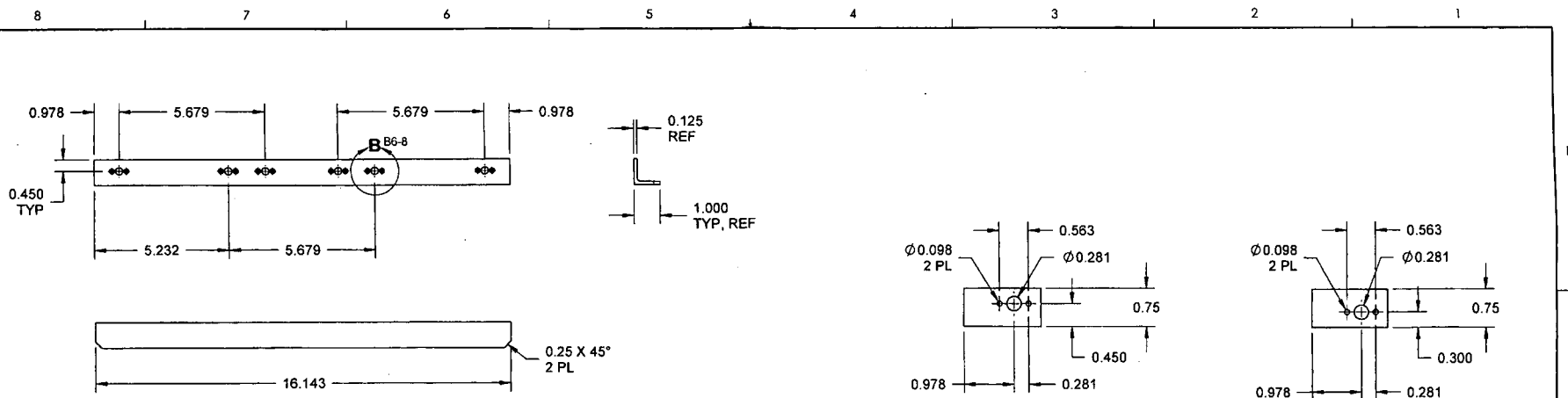
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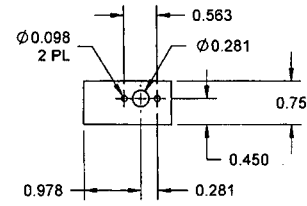
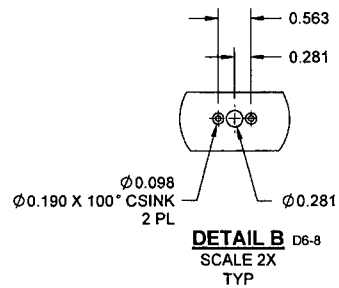
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.78 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D4172 SHEET 5 OF 7
APPROVED		TITLE SCALE
DE APPR.		POD MOUNTING FRAME ASSY NTS
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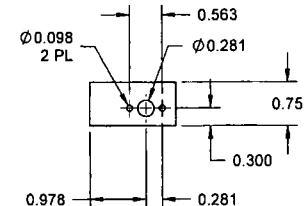




D4172-7 CROSSBAR



D4172-9 ANGLE



D4172-10 ANGLE

NOTES:

- 1) MATERIAL
D4172-7: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.00 X 1.00 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6207
D4172-9/-10: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.50 X 1.50 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6203
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4172-7 = 0.14 lbs; D4172-9/-10 = 0.01 lbs EACH

RELEASED
2010-09-29

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4172	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		POD MOUNTING FRAME ASSY	NTS
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